

WORK ORDER 2007-17

Date opened: 24 September 2007

Project: Quick Release Beams (High Basket)  
Type: Bell 206L/407Batch Quantity: 3 Forward Beam (76630-01)  
3 Aft Beam (76630-02)Approval: SH02-26  
Drawing List: DCL766-2

<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
76630, Rev. 0	Beams

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

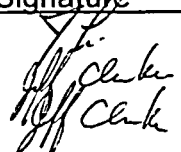
List all non-conformities raised: \_\_\_\_\_

<u>Jeff Clark</u>	<u>May 22/08</u>
Inspector Signature:	Date:

SEE WO 2007-21 FOR RELEASE TAGS

Drawing: 49222 Revision 2

Qty	Part #	Description	Material	P.O./W.O.	Checked
3	76630-01	Forward Beam			
3	76630-02	Aft Beam			
1	76630-03	Tube	304 Stainless 1.0 x 2.0 x 0.125 Tube	7006	
1	49222-04	Tube	304 Stainless 1.0 x 2.0 x 0.125 Tube	7006	
1	49222-05	Tube	304 Stainless 1.0 x 2.0 x 0.125 Tube	7006	
1	76630-06	Tube	304 Stainless 1.0 x 2.0 x 0.125 Tube	7006	
4	49222-07	Bushing	304 Stainless 0.625 Rod	6060	
4	49222-08	Bushing	304 Stainless 0.625 x 0.120 Tube	7008	
2	49222-09	Strap	304 Stainless 0.105 (12 Ga.) Sheet	7006	
2	76630-10	Cap	321 Stainless 0.025 Sheet	3021	
1	69830-10	Cap	321 Stainless 0.025 Sheet	3021	
1	69831-10	Cap	321 Stainless 0.025 Sheet	3021	
4	76630-13	Guide	304 Stainless 0.75 x 0.065 Tube	6049	
4	76630-14	Stop	6061-T6 Aluminum 0.75 Rod	3005	
4	76630-15	Pin	304 Stainless 0.313 Rod	6003	
2	69830-21	Stop	6061-T6 Aluminum 0.625 Rod	6061	
2	69830-22	Knob	6061-T6 Aluminum 0.75 Rod	3005	
2	69830-23	Spring	15mm x 70mm spring	6063	
4	69830-07	Block	304 Stainless 0.25 Sqr. Rod	7016	
4		#10-32 Stainless C'sunk Screw		6069	
4	MS21044C3	Nut		1013	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	Drawing 49222	ER308L Welding Rod		
Powder Coat	Drawing 49222			
Final Inspection	Drawing 49222			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Forward Beam Part #: 76630-01  
Approval #: SH00-48 Serial #: --  
WO #: 2007-17 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

Jan 30/08  
Date

Jeff Clarke  
Inspector's Signature

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Aft Beam Part #: 76630-02  
Approval #: SH00-48 Serial #: --  
WO #: 2007-17 Quantity: 1  
Eligibility: Bell 206L / 407 Work Status: Manufactured  
Remarks: \_\_\_\_\_

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

Jan 30/08  
Date

Jeff Clarke  
Inspector's Signature

NORTHERN  
AIR  
SUPPORT

VII

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Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Quick Release Forward Beam Part #: 76630-01

Approval #: SH00-48 Serial #: --

WO #: 2007-17 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

Remarks: \_\_\_\_\_

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May 22/08 Jeff Clarke  
Date Inspector's Signature

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AUTHORIZED RELEASE CERTIFICATE

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AMF # 73-04

Product: Quick Release Aft Beam Part #: 76630-02

Approval #: SH00-48 Serial #: --

WO #: 2007-17 Quantity: 1

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May 22/08 Jeff Clarke  
Date Inspector's Signature



VIH

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## AUTHORIZED RELEASE CERTIFICATE

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AMF # 73-04

Product: Quick Release Forward Beam Part #: 76630-01

Approval #: SH00-48 Serial #: --

WO #: 2007-17 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

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AMF # 73-04

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Approval #: SH00-48 Serial #: --

WO #: 2007-17 Quantity: 1

Eligibility: Bell 206L / 407 Work Status: Manufactured

Remarks: \_\_\_\_\_

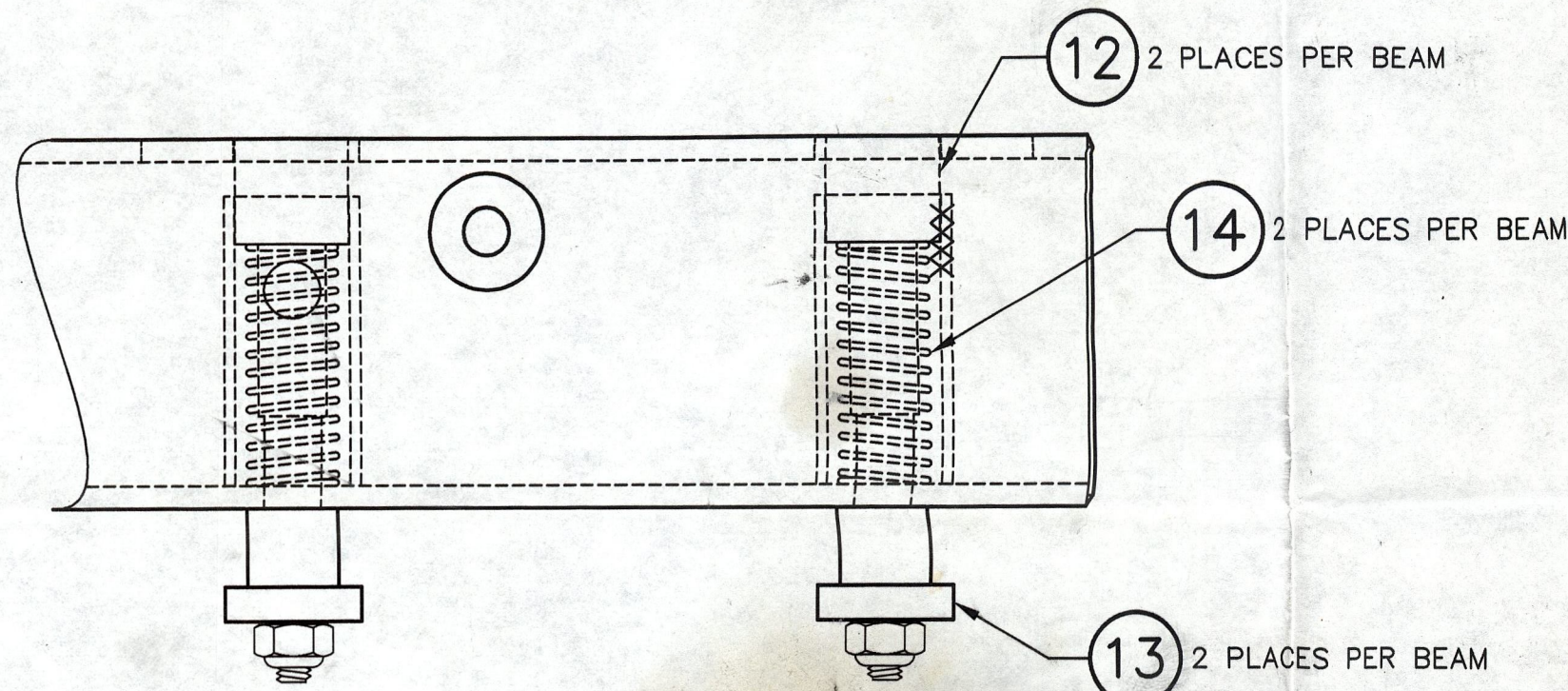
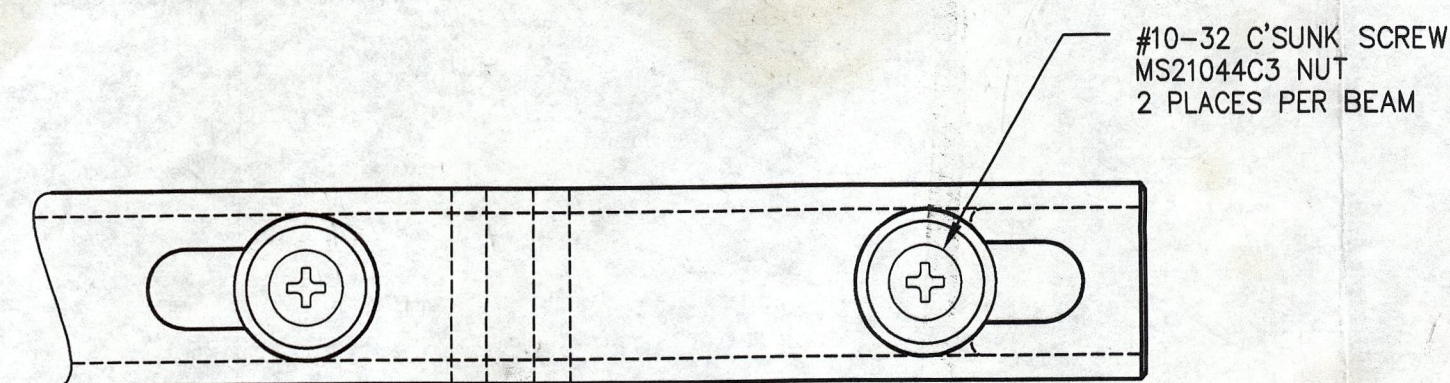
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May 22/08  
Date

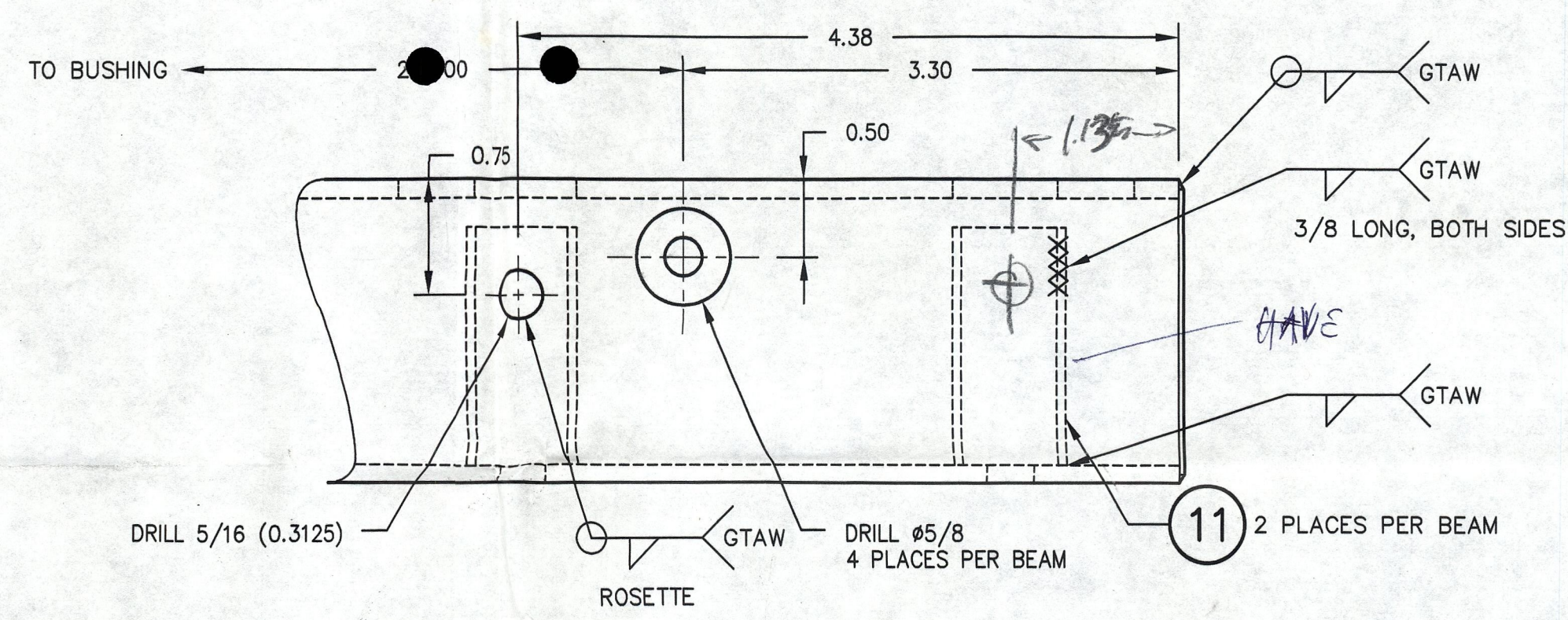
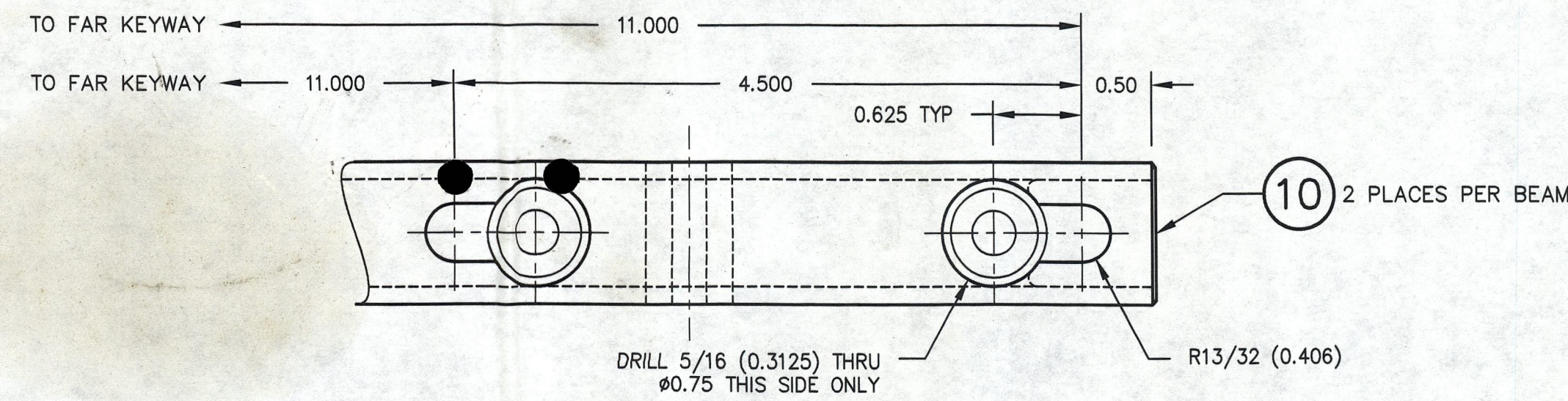
Jeff Clarke  
Inspector's Signature



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		
1	BEAMS MODIFIED FOR HIGH BASKET INSTALLATION	BJC	DEC 8/06
2	BEAMS MODIFIED FOR QUICK RELEASE HIGH BASKET INSTALLATION	BJC	SEPT 10/07

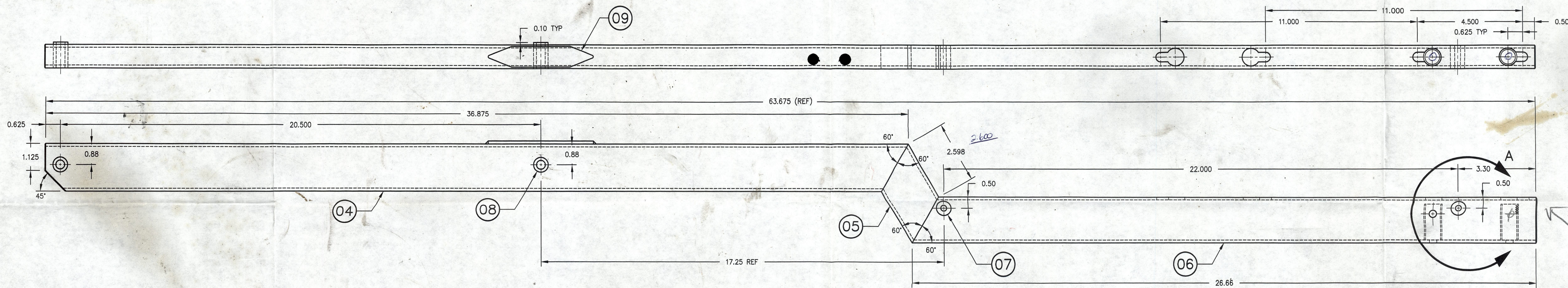


DETAIL A  
SCALE 1 : 1  
FINAL ASSEMBLY AFTER POWDER COATING

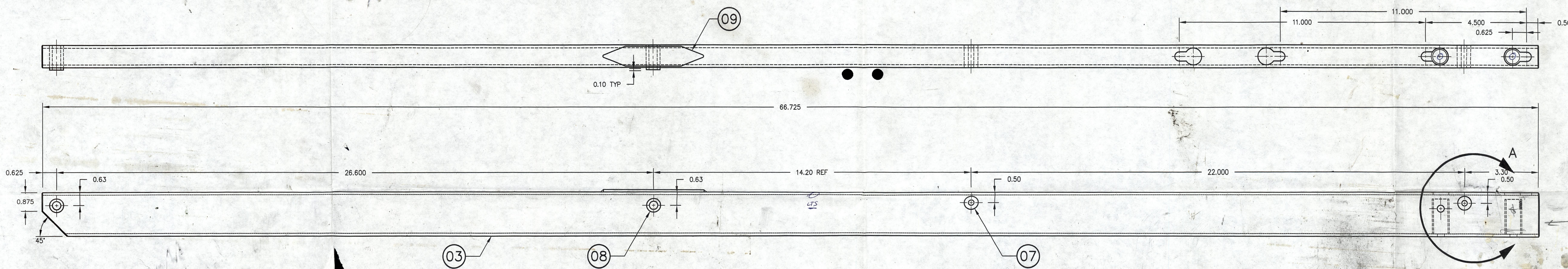


DETAIL A  
SCALE 1 : 1  
PRIOR TO ASSEMBLY OF STOP COMPONENTS

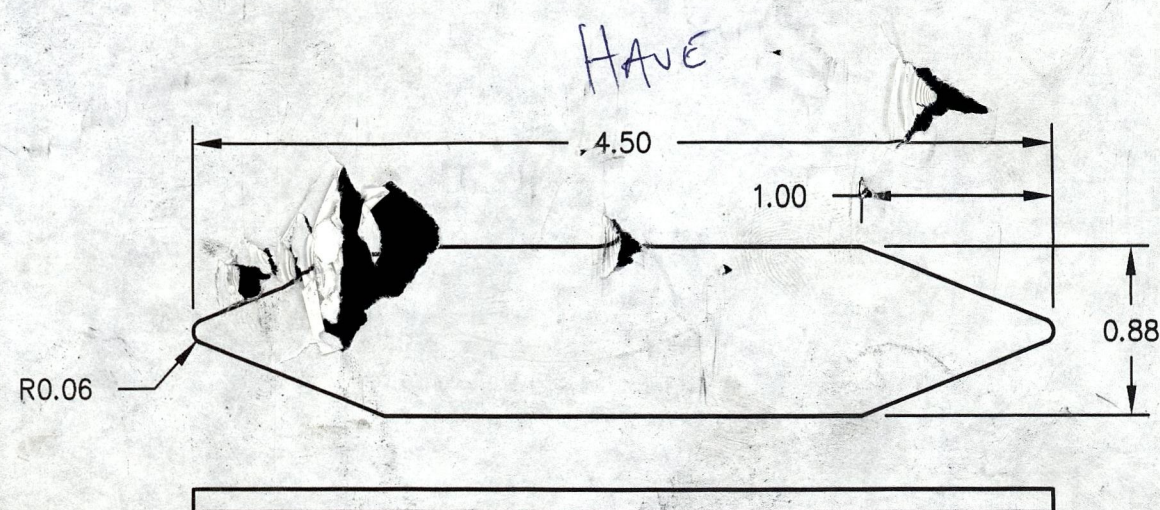
- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
  2. WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT FOR STAINLESS STEEL.
  3. ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.



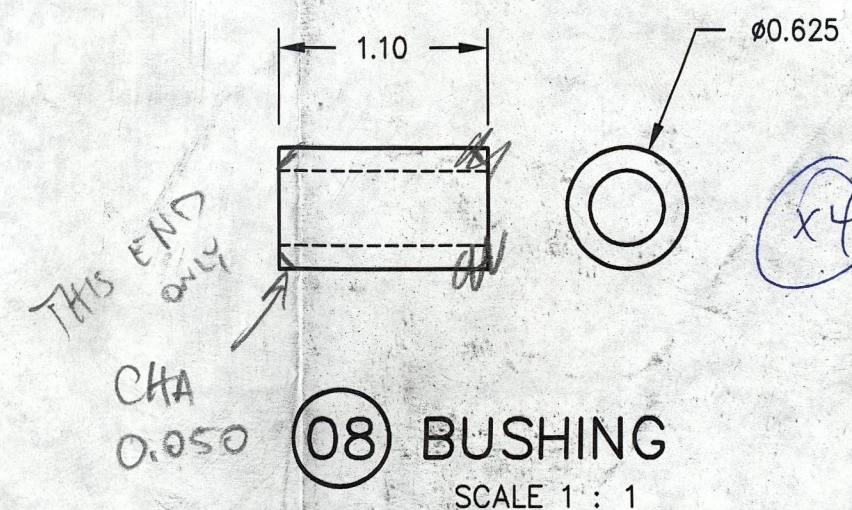
02 AFT BEAM ASSEMBLY



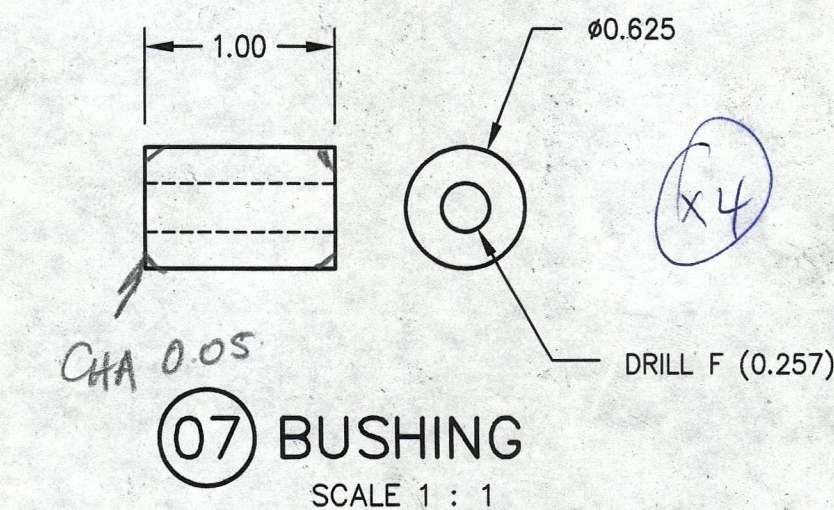
01 FORWARD BEAM ASSEMBLY



09 STRAP  
SCALE 1 : 1



08 BUSHING  
SCALE 1 : 1



07 BUSHING  
SCALE 1 : 1

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	MS21044C3	NUT		STAINLESS STEEL	COMMERCIAL	
2	2	#10-32	C'SUNK SCREW		STAINLESS STEEL	COMMERCIAL	
2	2	69830-23	14 SPRING		COMMERCIAL	15mm X 70mm SPRING	
1	1	69830-22	13 KNOB		6061-T6 ALUMINUM	QQ-A-200/8	#0.75 ROD
1	1	69830-21	12 STOP		6061-T6 ALUMINUM	QQ-A-200/8	#0.625 ROD
1	1	69830-11	11 GUIDE		304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
2	2	49223-10	10 CAP		321 STAINLESS STEEL	AMS 5510	0.025 SHEET
2	2	49222-09	09 STRAP		MIL-S-5069	0.105 SHEET (12 GA.)	
2	2	49221-08	08 BUSHING		304 STAINLESS STEEL	ASTM A213	0.625 X 0.120 TUBE
2	2	49221-07	07 BUSHING		304 STAINLESS STEEL	ASTM A479	0.625 ROD
1	1	49221-06	06 TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	49221-05	05 TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	49221-04	04 TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	49221-03	03 TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	49222-02	02 AFT BEAM ASSEMBLY				
1	1	49222-01	01 FORWARD BEAM ASSEMBLY				

APPROVALS	DATE
DRAWN: JEFF CLARKE	10 MAY 2006
CHECKED: E. BURGON	

UNLESS OTHERWISE SPECIFIED	DECIMALS	ANGLES
XXXX ±0.010		±1/2°
XXX ±0.03		
XX ±0.1		

AERO DESIGN LTD.	
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290X	
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7	
tel: (403) 850-8097 fax: (403) 850-1553	

BELL 206L & 407	
CARGO BASKET INSTALLATION	
BEAMS	
SCALE 1 : 2	DWG. NO. 49222
SHEET 1 OF 1	REV. 2